

# Work Order ID 61743

Wednesday, September 01, 2010 11:39:21 A

Page 1

Item ID: D3650-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Aft Panel

Start Date: 9/1/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 9/8/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-9-01

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3650

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3650 ☒ Dwg Rev: C ☐ Prog Rev: C ☐ 2-  
Deburr if necessary

304 .018

1B10-11-14

(6)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

1B10-11-4

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/10/10/05

(+6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 61743**

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Page 2

Item ID: D3650-1

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Revision ID:

Item Name: Aft Panel

Start Date: 9/1/2010 Start Qty: 6.00

Required Date: 9/8/2010 Req'd Qty: 6.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

0.00



Brake NC

NC BRAKE

Memo

0.00

Brake NC

Form as per Dwg D3650

SB 10/12/29

140

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

Scalizer

46

150

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D3650

EP 10/12/07 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Wednesday, September 01, 2010 11:39:21 A

Page 3

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Stop

Item Name: Aft Panel

Start Date: 9/1/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 9/8/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/12/08

x6

170

Identify as per dwg &amp; Stock Location: 189

0.00



Packaging

Memo

0.00

Packaging

10/12/09 629

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/09

mf

10-12-09

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, September 01, 2010 11:39:25 AM

Page 1

Work Order ID: 61743

Parent Item: D3650-1

Parent Item Name: Aft Panel





Start Date: 9/1/2010

Required Date: 9/8/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-09-27 DD verified by: EC  
IPP Rev:B ECN 1113P 08-01-22 DD verified by: EC  
IPP Rev:C ecn1162 08-04-02 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21062-3K  Nut Plate		Purchased	No			100	Each	244.0000	3	18			
<div> <div>Location</div> <div>ST302</div> <div>109590 ✓</div> </div> <div> <div>Loc Qty</div> <div>244</div> <div>244</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
M304S26GA  304/316 0.018 SHEET		Purchased	No			150	sf	144.0000	1.583	9.997895			
<div> <div>Location</div> <div>MAT20</div> <div>109398</div> <div>112885</div> </div> <div> <div>Loc Qty</div> <div>144</div> <div>48</div> <div>96</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
MS20427M3-3  Rivet		Purchased	No			150	Each	195.0000	18	108			
<div> <div>Location</div> <div>ST318</div> <div>115589</div> <div>115409</div> </div> <div> <div>Loc Qty</div> <div>195</div> <div>195</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
MS21060-3K  Nut Plate		Purchased	No			150	Each	154.0000	6	36			
<div> <div>Location</div> <div>ST302</div> <div>109590 ✓</div> </div> <div> <div>Loc Qty</div> <div>154</div> <div>154</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

*m-l 10/12/02*

*18X*

*1810-11-4*

*(6)*

*109398*

*m-l 10/12/02*

*108*

*m-l 10/12/02*

*36X*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	617413
<b>Description:</b> Aft Panel		<b>Part Number:</b>	D3650-1
<b>Inspection Dwg:</b> D3650	<b>Rev:</b> C	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.105	*		V 1302	
Ø0.213	+0.005/-0.001	.218	*		V	
Ø0.250	+0.005/-0.001	.255	*		V	
0.25	+/-0.030	.248	*		V	
0.344	+/-0.010	.343	*		V	
0.35	+/-0.030	.350	*		V	
0.312	+/-0.010	.313	*		V	
2.26	+/-0.030	2.261	*		V	
7.18	+/-0.030	7.182	*		V	
9.55	+/-0.030	9.55	*		V	
10.66	+/-0.030	10.66	*		T 1301	
12.02	+/-0.030	12.02	*		T	
16.65	+/-0.030	16.625	*		T	
17.58	+/-0.030	17.58	*		T	
16.61	+/-0.030	16.61	*		T	
0.12	+/-0.030	.125	*		V	
0.17	+/-0.030	.167	*		V	
15.80	+/-0.030	15.80	*		T	
3.950	+/-0.010	3.948	*		V	
2.02	+/-0.030	2.017	*		V	
4.03	+/-0.030	4.028	*		V	
6.13	+/-0.030	6.121	*		V	
8.23	+/-0.030	8.23	*		T	
10.31	+/-0.030	10.31	*		T	
12.25	+/-0.030	12.25	*		T	
0.018	+/-0.010	.019	*		V	

<b>Measured by:</b>	RB	<b>Audited by:</b>	S	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	10-11-4	<b>Date:</b>	10/11/05	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.07.24	New Issue	KJ/DD	
B	09.06.15	Dimensions updated per Dwg Rev C	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

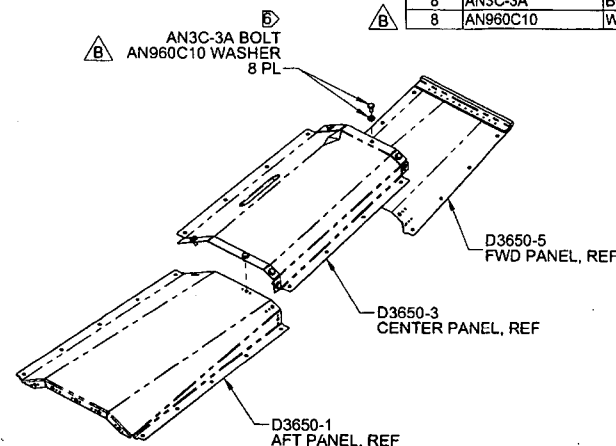
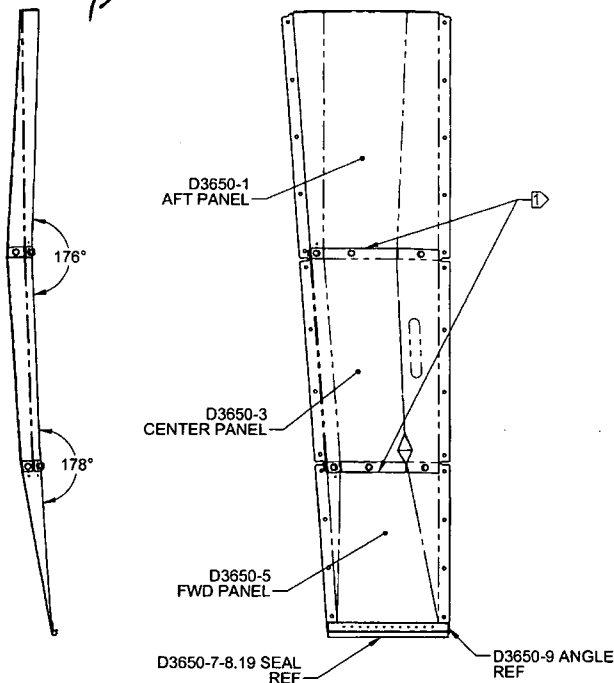
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**NOTE:** Date & initial all entries

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 41743 BS10-9-01

QTY	PART NUMBER	DESCRIPTION
X	D3650-041	TUNNEL TOP PANEL ASSEMBLY
1	D3650-1	AFT PANEL
1	D3650-3	CENTER PANEL
1	D3650-5	FWD PANEL
8	AN3C-3A	BOLT
8	AN960C10	WASHER



DEO ATTACHED

UNDER REVIEW

RELEASED

### D3650-041 TUNNEL TOP PANEL ASSEMBLY

#### NOTES:

- 1) SEAL ALL MATING SURFACES AND ALL GAPS USING PROSEAL 700 FIRE WALL SEALANT
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 5) IDENTIFICATION: NONE
- 6) TORQUE FASTENERS 15 TO 25 in-lb
- 7) WEIGHT: 3.3 lbs

C	REFORMATTED TO NEW STANDARDS; RELOCATED PART LIST (ZN D2-2); ADDED SECTION VIEW J-J & REVISE DIMENSIONS (ZN B7-5, C4-5); ADDED RECESS LOCATION & REVISED DIMENSIONS (ZN C6-6, D5-6); MS20615-4M5 WAS CR3523-4-03 & NAS1149CN432R WAS AN960C4 (ZN D5-7, B5-7, B8-7)	RF	08.10.14
B	SHEETS 1, 2 & 7: UPDATED FASTENER QUANTITIES; UPDATED VIEWS SHEETS 3 & 8: REMOVED/RELOCATED HOLES; UPDATED VIEWS SHEET 4: 1.8 WAS 1.5; 1.0 WAS 0.8; UPDATED VIEW; ADDED NOTE 8 SHEET 5: REMOVED NOTE IN C6 & ASSOCIATED DIMS; UPDATED VIEWS SHEET 6: REMOVED/RELOCATED HOLES & ADDED CUTOUT TO D3650-3F; MOVED D3650-11/-11F TO SHEET 9; ADDED DETAIL I SHEET 9: RELOCATED D3650-11/-11F FROM SHEET 6; UPDATED DIMS O: D3650-11/-11F	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3650	SHEET 1 OF 9
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	TOP PANEL ASSEMBLY	1:8
DATE	08.10.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

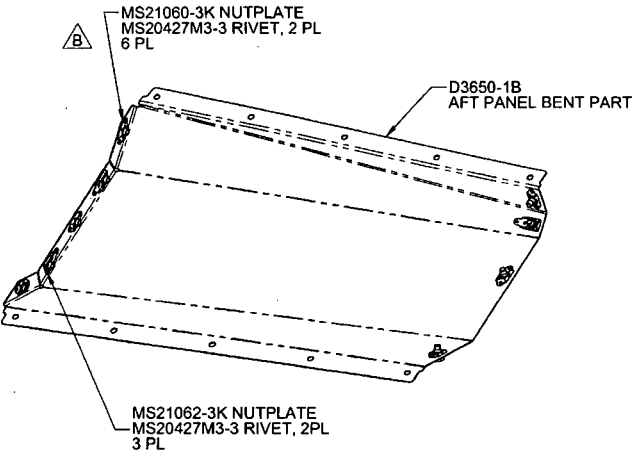
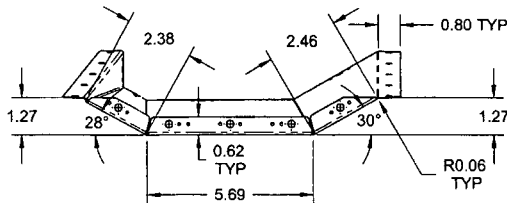
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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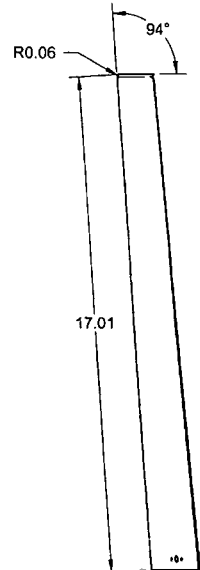
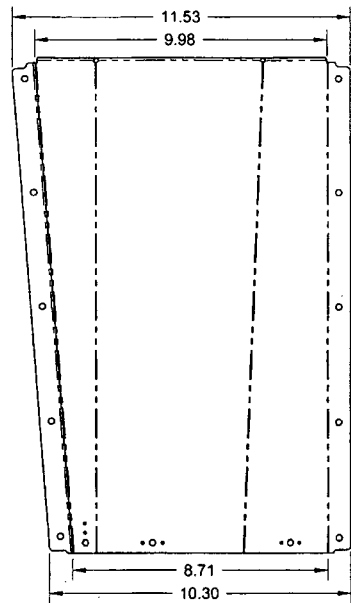
**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

QTY	PART NUMBER	DESCRIPTION
X	D3650-1	AFT PANEL
1	D3650-1B	AFT PANEL BENT PART
18	MS20427M3-3	RIVET
6	MS21060-3K	NUTPLATE
3	MS21062-3K	NUT PLATE



D3650-1 AFT PANEL



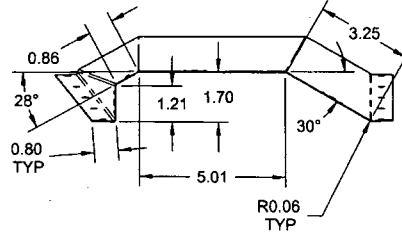
w/b 61743

DEO ATTACHED

UNDER REVIEW

RELEASED

D3650-1B AFT PANEL BENT PART  
(MAKE FROM D3650-1F FLAT PATTERN)



- NOTES:
- 1) FINISH: NONE
  - 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 3) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 5) IDENTIFICATION: NONE
  - 6) WEIGHT: 1.3 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3650	SHEET 2 OF 9
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	NTS
DATE	08.10.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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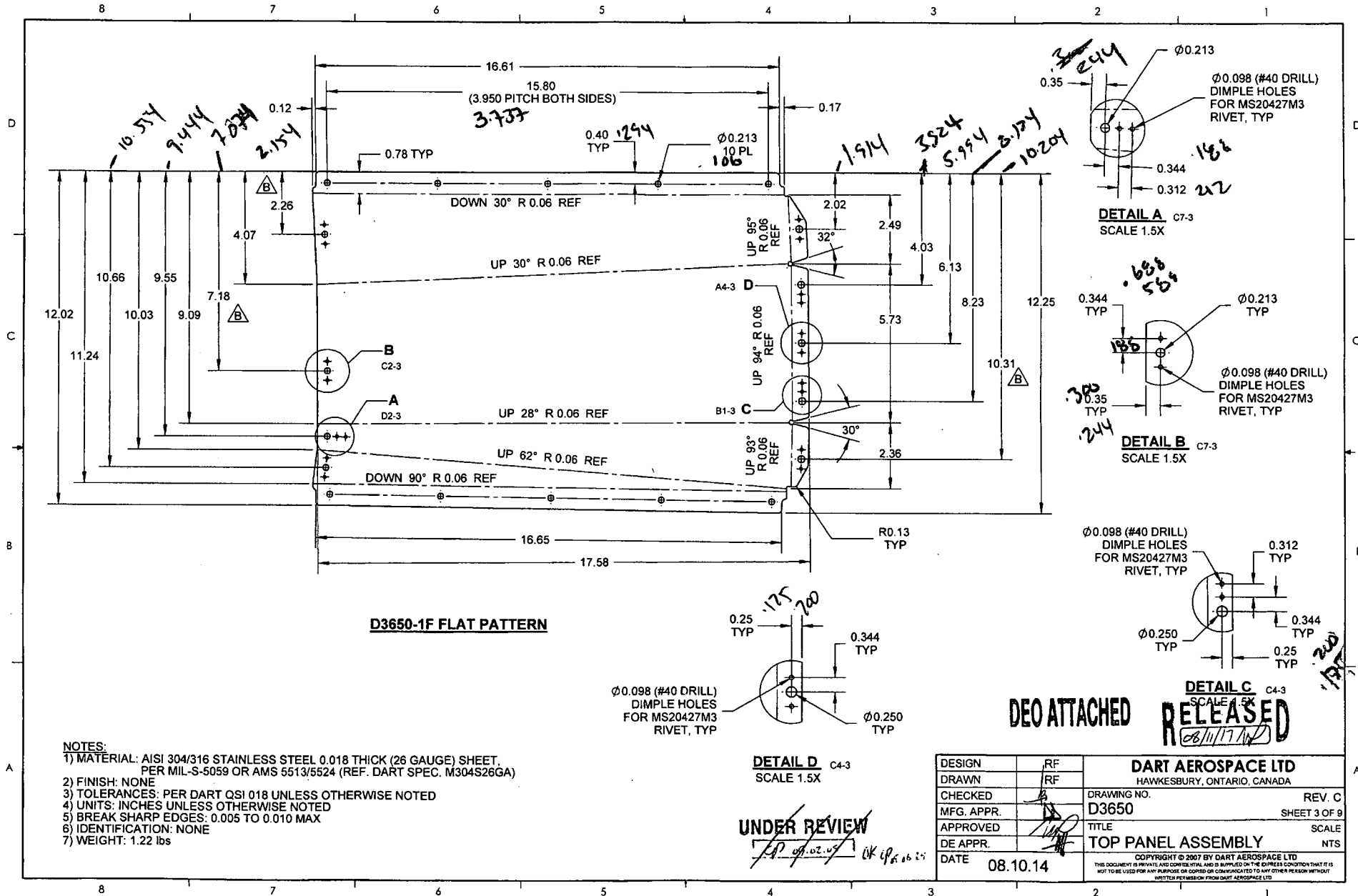
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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W/O 61743



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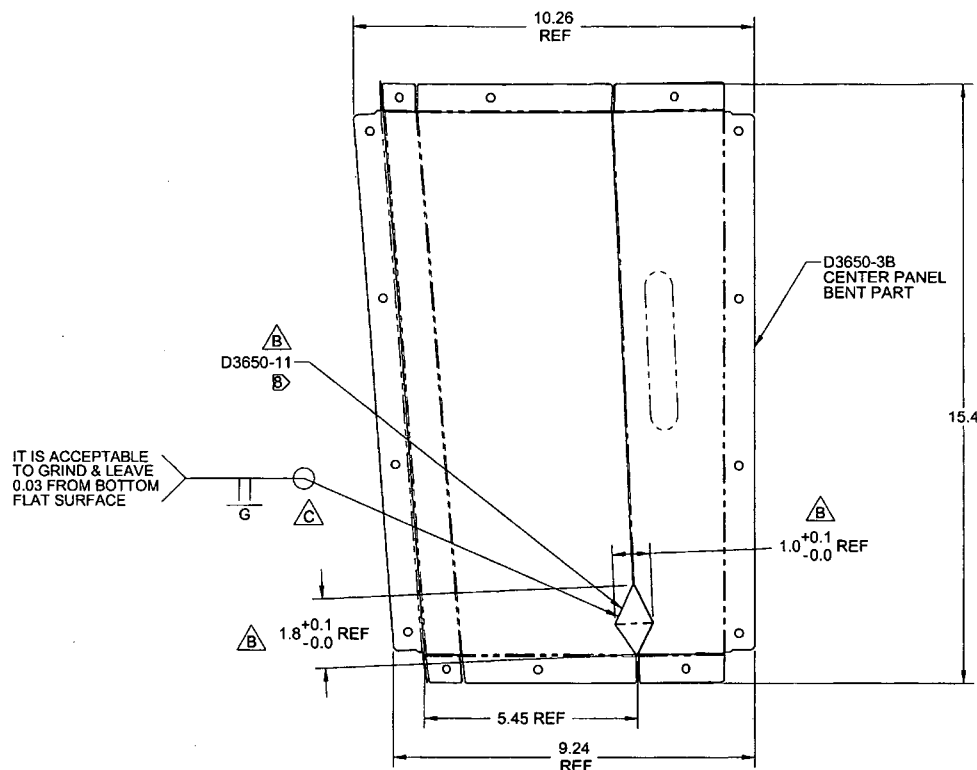
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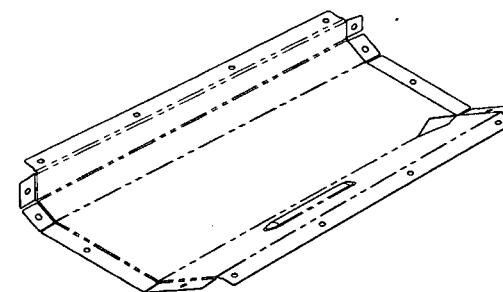
**NOTE:** Date & initial all entries



QTY	PART NUMBER	DESCRIPTION
3	D3650-3	CENTER PANEL
1	D3650-3B	CENTER PANEL BENT PART
1	D3650-11	FILLER PLATE



**D3650-3 CENTER PANEL**  
(LOOKING FROM OUT SIDE SURFACE)



W/0 61743

DEO ATTACHED

RELEASED  
08.11.17

**NOTES:**

- 1) WELD PER QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.0 lb
- 8) TRIM D3650-11 TO FIT AS REQUIRED

UNDER REVIEW

08.12.05  
08.06.24

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3650	SHEET 4 OF 9
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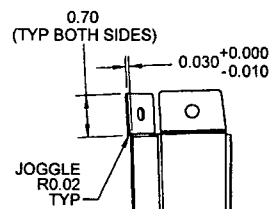
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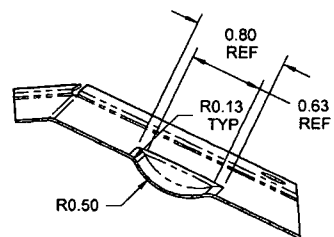
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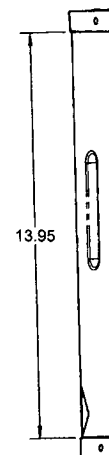
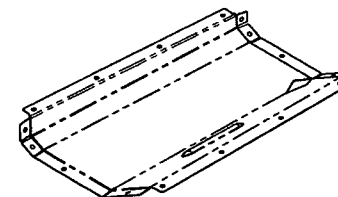
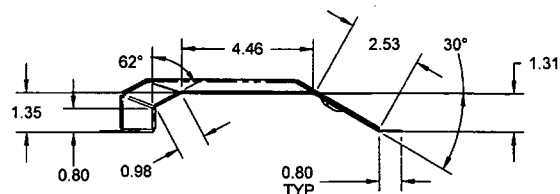
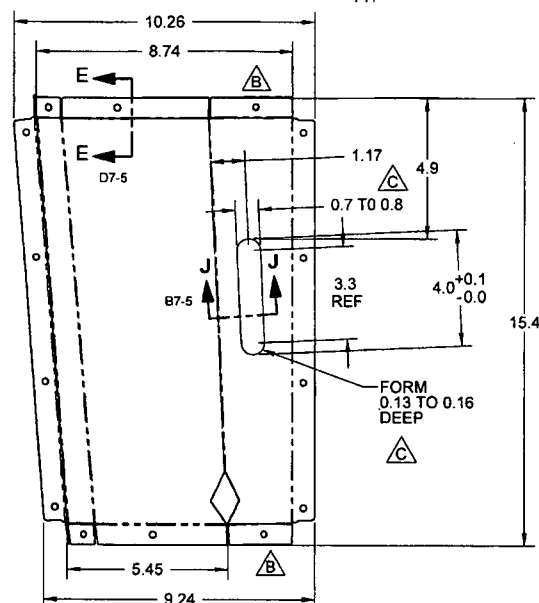
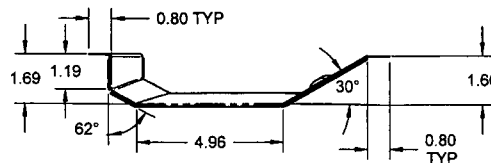
**NOTE:** Date & initial all entries



**SECTION E-E** D5-5  
SCALE 2X



**SECTION J-J** C5-5  
SCALE 3.5X



u1061743

DEO ATTACHED

RELEASED  
08/11/17

- NOTES:  
1) FINISH: NONE  
2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
3) UNITS: INCHES UNLESS OTHERWISE NOTED  
4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
5) IDENTIFICATION: NONE

**D3650-3B CENTER PANEL BENT PART**  
(MAKE FROM D3650-3F FLAT PATTERN)

UNDER REVIEW  
13 09 2014 OK 4. 24

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3650	SHEET 5 OF 9
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	NTS
DATE	08.10.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

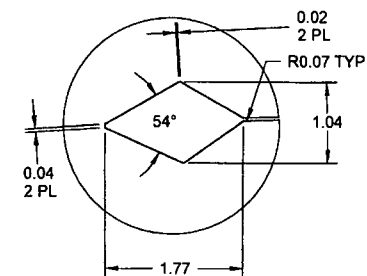
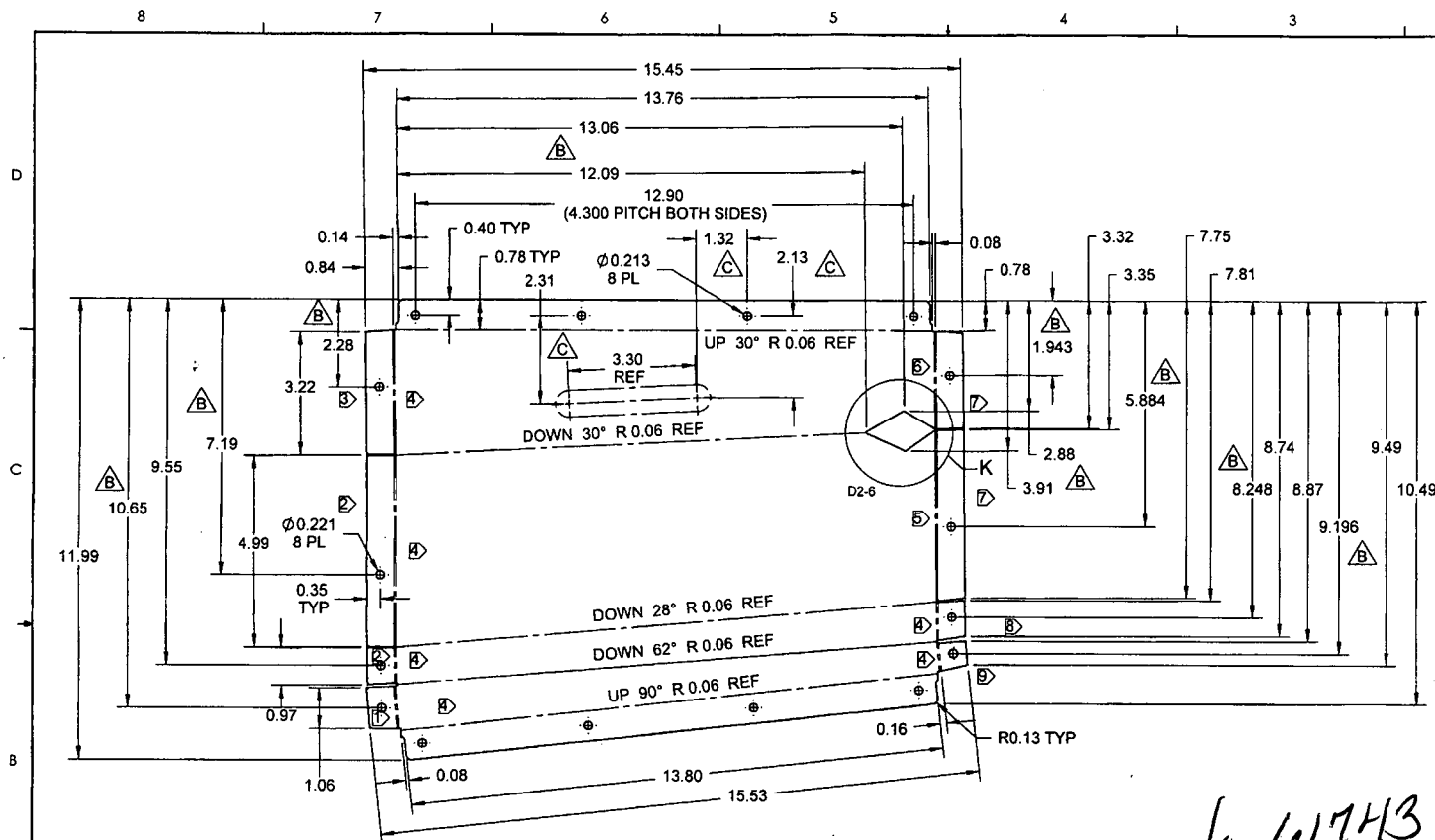
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



C5-6 **DETAIL K**  
SCALE 2X

**DEO ATTACHED**

- ① DOWN 92° R0.015
- ② DOWN 89° R 0.015
- ③ DOWN 86° R 0.015
- ④ UP 90° R 0.015
- ⑤ UP 88° R 0.015
- ⑥ UP 90° R 0.015
- ⑦ DOWN 88° R 0.015
- ⑧ DOWN 90° R 0.015
- ⑨ DOWN 94° R 0.015

**RELEASED**  
08/11/14

**D3650-3F CENTER PANEL FLAT PATTERN**

**D3650-3F NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5059 OR AMS 5513/5524 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE

**UNDER REVIEW**

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		<b>D3650</b>	SHEET 6 OF 9
APPROVED		TITLE	SCALE
DE APPR.		<b>TOP PANEL ASSEMBLY</b>	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

MS21062-3K NUTPLATE  
MS20427M3-3 RIVET, 2 PL  
2 PL

MS21060-3K NUTPLATE  
MS20427M3-3 RIVET, 2 PL  
2 PL

NAS1149CN432R  
WASHER, REF

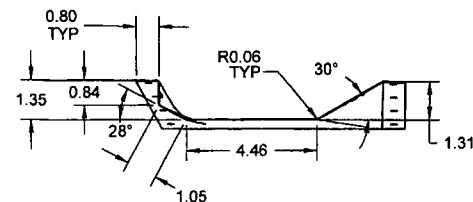
0.74  
0.07

D3650-5B FWD PANEL  
BENT PART  
REF

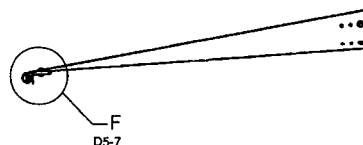
MS20615-4M5  
RIVET, REF

D3650-7-8.19 SEAL  
D3650-9 ANGLE

DETAIL F  
SCALE 3.5X



D3650-5B  
FWD PANEL  
BENT PART  
REF



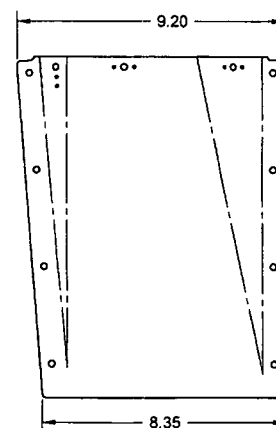
D3650-9 REF

D3650-7-8.19  
REF

D3650-5B  
FWD PANEL  
BENT PART

CENTRE D3650-7/-9 ON D3650-5B &  
TRANSFER Ø0.129 (#30 DRILL) HOLES  
FROM D3650-9 TO D3650-7 & D3650-5B  
AS SHOWN  
INSTALL  
MS20615-4M5 RIVET  
NAS1149CN432R WASHER  
12 PL

D3650-5 FWD PANEL



DEO ATTACHED

D3650-5B FWD PANEL BENT PART  
(MAKE FROM D3650-5F FLAT PATTERN)

# PART LIST

QTY	PART NUMBER	DESCRIPTION
X	D3650-5	FWD PANEL
1	D3650-5B	FWD PANEL BENT PART
1	D3650-7-8.19	SEAL
1	D3650-9	ANGLE
12	NAS1149CN432R	WASHER
12	MS20615-4M5	RIVET
8	MS20427M3-3	RIVET
2	MS21060-3K	NUTPLATE
2	MS21062-3K	NUTPLATE

## NOTES:

- MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5059 OR AMS 5513/5524 (REF. DART SPEC. M304S26GA)
- FINISH: NONE
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- IDENTIFICATION: NONE
- WEIGHT: 0.8 lbs

UNDER REVIEW  
01.02.05  
02.09.06.24

DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3650
MFG. APPR.		REV. C
APPROVED		SHEET 7 OF 9
DE APPR.		TITLE TOP PANEL ASSEMBLY
DATE	08.10.14	SCALE NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

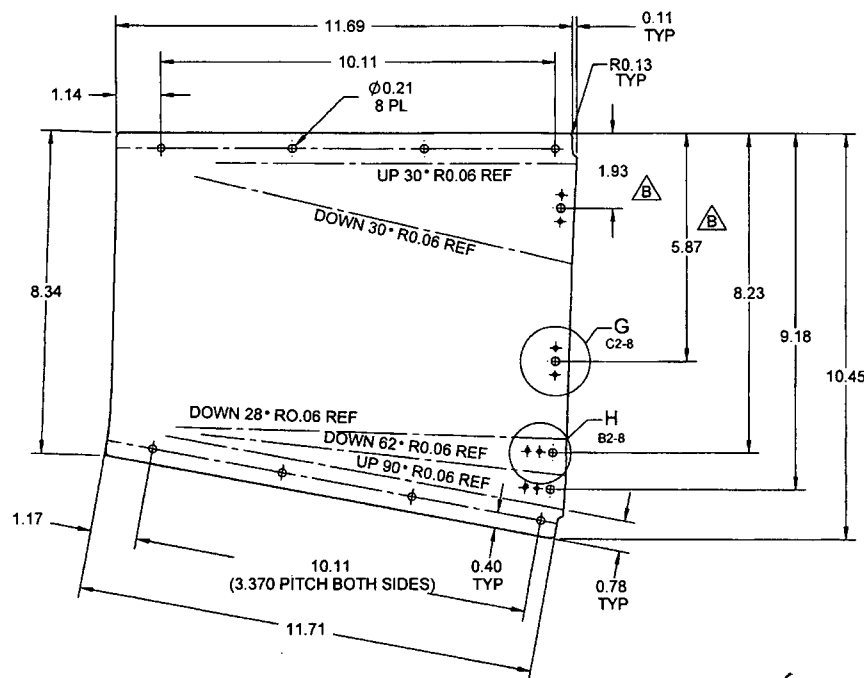
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

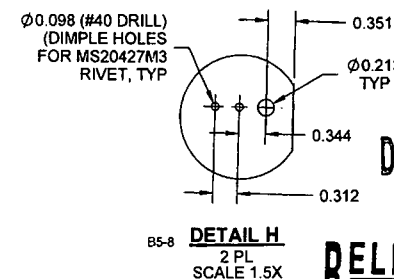
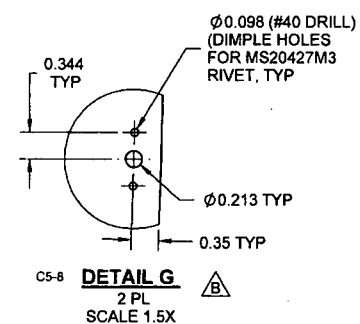
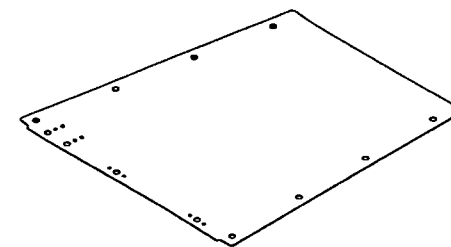
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**D3650-5F FLAT PATTERN**



DEO ATTACHED

RELEASED  
08/11/17

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5059 OR AMS 5513/5524 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.6 lb

UNDER REVIEW  
TOP 07.07.17  
OK 07.06.17

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED			DRAWING NO.	REV. C
MFG. APPR.			D3650	SHEET 8 OF 9
APPROVED			TITLE	SCALE
DE APPR.			TOP PANEL ASSEMBLY	NTS
DATE	08.10.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		

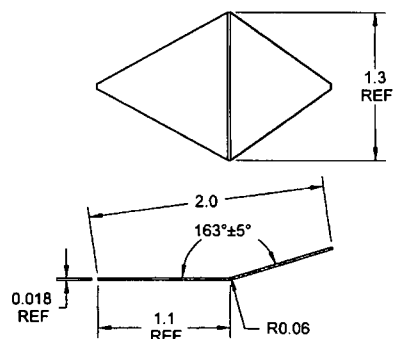
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

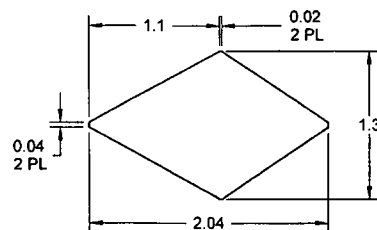
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

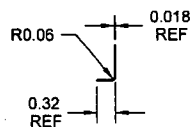
**NOTE:** Date & initial all entries



**D3650-11 FILLER PLATE**  
(MAKE FROM D3650-11F FLAT PATTERN)



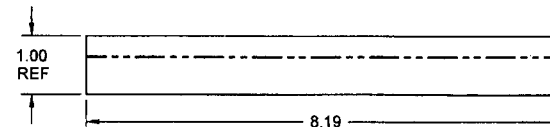
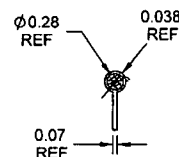
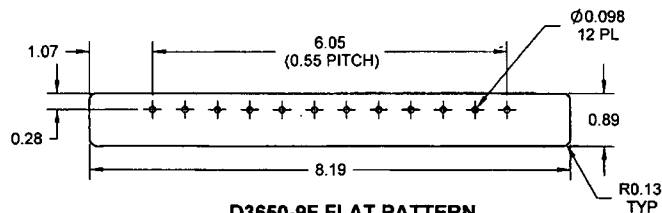
**D3650-11F FLAT PATTERN**



**D3650-9 ANGLE**  
(MAKE FROM D3650-9F FLAT PATTERN)



**D3650-9F FLAT PATTERN**



**D3650-7-8.19 SEAL**

**D3650-9 & D3650-11 NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5059 OR AMS 5513/5524 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) D3650-9 WEIGHT: 0.05 lb  
D3650-11 WEIGHT: 0.007 lb

**D3650-7-8.19 NOTES:**

- 1) MATERIAL: P/N 8168-1 TADPOLE SEAL (REF. BELL P/N 120-104-1)  
POSSIBLE SUPPLIER: EAGLE COPTERS OR BELL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.05 lb
- 8) PART NUMBER: D3650-7-X.XX  
WHERE X.XX = LENGTH IN INCHES  
EG. 12.50" LONG = D3650-7-12.50

DEO ATTACHED

RELEASED  
08/10/14

WLO 61743

UNDER REVIEW  
08/07/14  
OK 08/14/14

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	B	DRAWING NO.	REV. C
MFG. APPR.	14	D3650	SHEET 9 OF 9
APPROVED	14	TITLE	SCALE
DE APPR.	14	TOP PANEL ASSEMBLY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DRAWING NO. D3650	TITLE TOP PANEL ASSEMBLY	REV. C	<b>DART AEROSPACE LTD ENGINEERING ORDER</b>	D.E.O. NO. D3650-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN CP	CHECKED	MFG. APPR. <i>EC</i>	APPROVED <i>MD</i>	DE APPR. <i>MD</i>		
DATE 09.06.12	DATE 04.06.15	DATE 09.06.15	DATE 09/06/15	DATE 09/06/15		

**TO AMEND D3650-5 FWD PANEL:**

REF PAR 09-008. THE QTY(12) NAS1149CN432R WASHERS ARE REPLACED WITH QTY(1) D3893-1 DOUBLER. THE QTY(12) MS20615-4M5 RIVETS ARE REPLACED WITH QTY(12) NAS9307M-4-03 RIVETS. LOCATION OF THE DOUBLER IS SHOWN IN THE AMENDED DETAIL F (DWG SHEET 7) BELOW. THE PARTS LIST FOR D3650-5 IS AMENDED AS FOLLOWS:

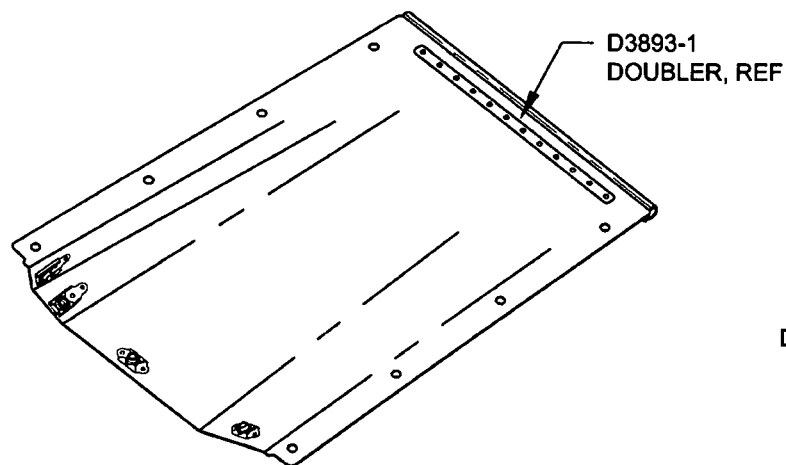
**IS:**

QTY	PART NUMBER	DESCRIPTION
-5		
1	D3893-1	DOUBLER
12	NAS9307M-4-03	RIVET (OR CR3523-4-03)

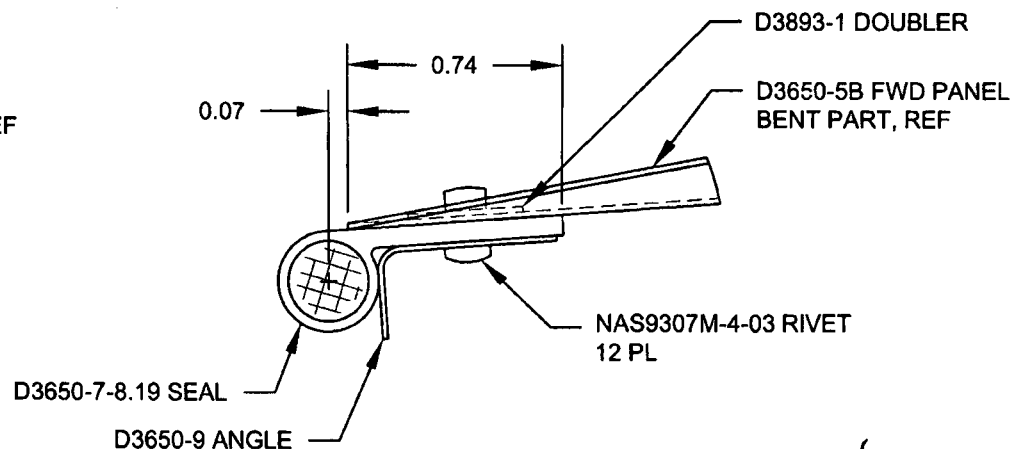
**WAS:**

QTY	PART NUMBER	DESCRIPTION
-5		
12	NAS1149CN432R	WASHER
12	MS20615-4M5	RIVET

**RELEASED**  
09/06/15



**D3650-5 FWD PANEL**



**DETAIL F** C5-7  
SCALE 3.5X

W/O 41743

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries